

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011710**Date Inspected:** 29-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG TRIAL ASSEMBLY

This QA Inspector observed the following work in progress:

SEGMENT: 6CW-7AW

Flux Cored Arc Welding (FCAW) welding of weld joint SEG031F-011. Welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

SEGMENT: 6CW-7AW

Flux Cored Arc Welding (FCAW) welding of weld joint SEG031F-009. Welder is identified as 068091. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

SEGMENT: 6CW-7AW

Flux Cored Arc Welding (FCAW) welding of weld joint SEG031F-010. Welder is identified as 068091. ZPMC

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Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

SEGMENT: Crossbeam-CB6

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint CB202A-006-002. Welder is identified as 215248. ZPMC Quality Control (QC) is identified as Mr. Zheng Zhi Wei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F)-Repair and Critical Welding Repair Report (CWR) no is B-CWR-997.

SEGMENT: 6AE - Corner Assembly Cross Brace (North and South)

(Except 5 locations @ PP37 (N&S), PP39(S), PP41 (N&S) to west direction, total 22 bolts.)

This Quality Assurance (QA) Inspector witnessed final tension verification for Catwalk at Corner Assembly area from Panel Point (PP) 37 and PP 41 for Segment 6AE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00246 Dated: January 29, 2010.

Bolt sizes used were M24 x 65 Set# DHGM240008 and final torque value was 547 N-m.

Bolt sizes used were M24 x 60 Set# DHGM240014 and final torque value was 567 N-m.

Bolt sizes used were M24 x 80 Set# DHGM240011 and final torque value was 533 N-m.

Bolt sizes used were M22 x 55 Set# DHGM220001 and final torque value was 443 N-m.

Bolt sizes used were M22 x 85 Set# DHGM220013 and final torque value was 443 N-m.

Bolt sizes used were M22 x 120 Set# DHGM220053 and final torque value was 440 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-762/X02-667.

Signed off Green Tag's

This Quality Assurance (QA) Inspector witnessed final tension verification for following depicted locations. Corner Assembly area from Panel Point (PP) 37 and PP 41 for Segment 6AE. Inspected 10% on a random basis and found the tension to be in general compliance and thus signed off the Green Tags.

Green Tag Number's as follows:

1.583~588.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

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Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra
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Quality Assurance Inspector

Reviewed By:	Miller,Mark
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QA Reviewer
